



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB23007615-11
Job Sheet 187698



Part No: RB23007615-11

Job Qty: 10 ea 9

Part Name: #12 Drill Bit



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/12/18

Job Tracking No:

Due Date: 1/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB23007615 REV B IPP REV A 18.02.20 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/10/19	1/10/19	0.00	0.00	Start Up Machining-3		JB 19-01-12
110	CNC Lathe	10 pcs	1/10/19	1/10/19	0.00	3.33	SL-154		JB 19-01-12
120	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC2 Machining-4		JB 19-01-12
130	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC8 Machining-4		JB 19-01-14
140	Outsource	10 pcs	1/10/19	1/10/19			ATC001-VC (Altech)	10	19-01-14
142	Packaging	10 pcs	1/10/19	1/10/19	0.00	0.00	Packaging2		JAN 2 1 2019
144	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC6		38
146	Small Fab	10 pcs	1/10/19	1/10/19	0.00	0.00	Small Fab-1		MLC 38
148	QC	10 pcs	1/10/19	1/10/19	0.00	0.00	QC5		38
180	Packaging	10 pcs	1/10/19	1/10/19	0.00	0.00	Packaging3-1		21
190	QC21-SA	10 Ea	1/10/19	1/10/19	0.00	0.00	QC21		JAN 2 4 2019

Part Op 110 - 1-Machine (-2 block) as per folio FC032 FOLIO REV: _____ DWG REV: _____ 2- Deburr

Descriptions: 120 - 1- Engrave drill sizes using Marktronic engraver as per DWG RB23007615 sheet #2.

140 - Issue P/O to ATC, PO 042256 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

146 - 1- Assemble #12 drill bit into RB23007615-2 with Loctite clear multipurpose.

GA 140

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6H0.312	6061-T6 Hex Bar .312	.9000 ft (.09 ea)	90-Start up Operation	5084012.
AC40112	No. 12 Us 118 Pol Hs Job Drill	10 Ea (1 ea)	146-Small Fab	685104722 3x5088970

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6H0.312	1	6	0
146-Small Fab	AC40112	10	20	0



Container No: S144373

Part: RB23007615 - 11

Job No: 187698

Serial No/Batch: S144373

Revision: B

Inspector:

Exp Date:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ifications

uld not be found.

Plex 12/12/18 7:31 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

INSPECTION SHEET

[illegible]

Measured by: JB 9-89	Checked by: B.	QC Inspector:
Date: 19-01-12	Date: 19-01-14	Date:

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

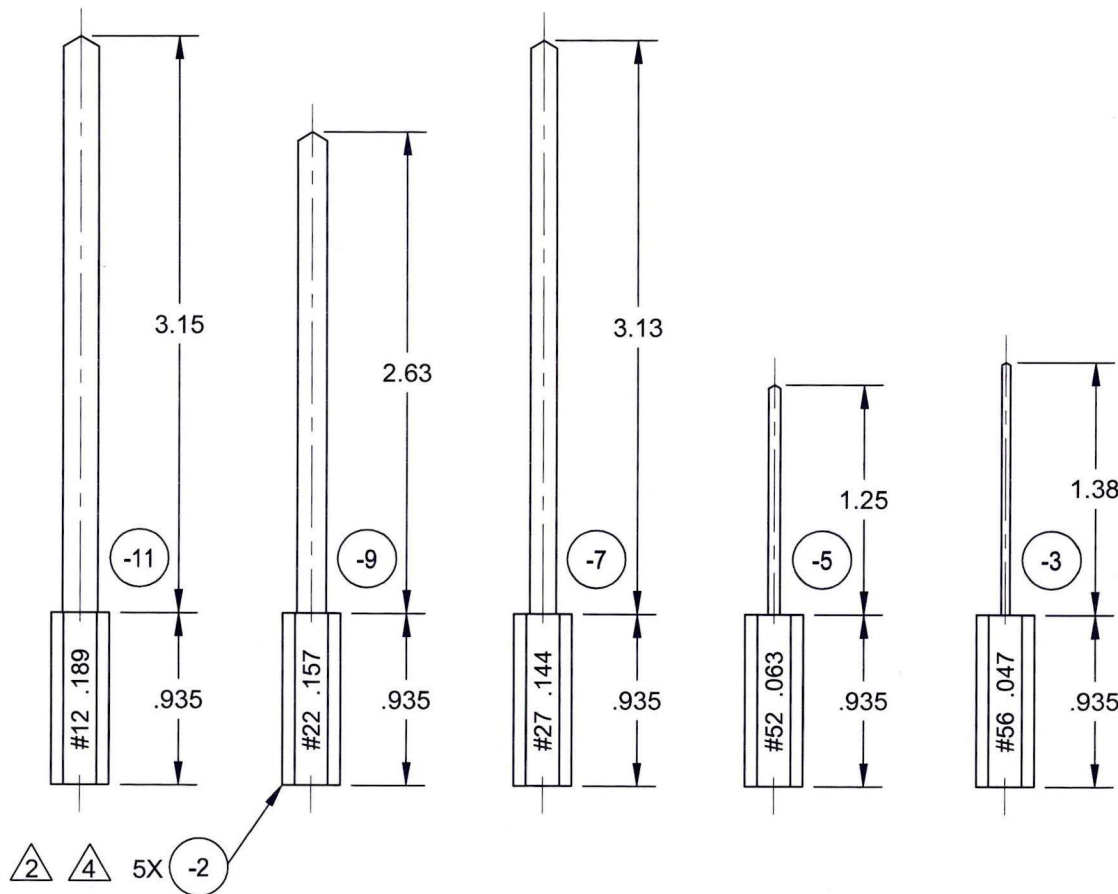
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS		DATE	INITIAL	APPROVED
REV	DESCRIPTION			
B	-2 ADDED NOTES TO SHEET.	2/3/14	DPD	RJC

TEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187698 HCS
18-12-12



NOTES:

- CHECK EACH HOLE FOR PROPER EXPOSED DRILL LENGTH.
- 2 TO BE DRILLED FOR BIT TO ACHIEVE EXPOSED DRILL LENGTH.
- EPOXY BIT INTO -2 AFTER ANODIZING.
- ANODIZE BLACK MIL-A-8625F, TYPE II, CLASS II

RED BARN MACHINE

TITLE POWER TURBINE CLEANING KIT

DWG NO. RB23007615-2 THRU -11 **REV** B

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
XXX ± .005
XX ± .01
X ± .1
FRACTIONS ± 1/32
ANGLES ± 5°
DRAWN BY: COLE
APPROVED: *D Weil*
HEAT TREAT
FINISH SPEC
SEE NOTE 4

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
USED ON MODEL
ALLISON C30

SCALE 1:1 **DATE** 2-1-01 **SHEET** 2 of 7

 DART AEROSPACE Hawkesbury, Ontario, Canada	ENGINEERING ORDER # TEO17-646			SCALE: NTS	SHEET 1 OF 1
	DRAWING NO. RB23007615	REV: B	EFF.: NEXT ORDER	CHANGE CATEGORY	
	TITLE: POWER TURBINE CLEANING KIT			☐ MAJOR ☒ MINOR	DATE 17.09.08
	APPROVED: WM 10/03/2017 	MFG. APPR.: DP 09/28/2017		CHECKED: SAC 09/28/2017	DRAWN: VM 09/28/2017
TRANSACTION CODE (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: EPOXY DETAILS MISSING			COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
WAS : PART# RB23007615-2 THRU -11 Rev B NOTE 3 : EPOXY BIT INTO -2 AFTER ANODIZING IS : PART# RB23007615-2 THRU -11 Rev B NOTE 3 : LOCTITE CLEAR MULTIPURPOSE INTO -2 AFTER ANODIZING					
DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM					

EEEN 17-646



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042256



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042256
PO Date: 1/14/19
Due Date: 1/21/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187698	RB23007615-11	#12 Drill Bit -Issue P/O to Altech; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	1/21/19	10 pcs	0 pcs	10 pcs	\$2.3076923/pcs	\$23.08
2	187706	RB23007615-9	#22 Drill Bit -Issue P/O to Altech; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	1/21/19	10 pcs	0 pcs	10 pcs	\$2.3076923/pcs	\$23.08
3	187704	RB23007615-5	#52 Drill Bit -Issue P/O to ATG; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	1/21/19	10 pcs	0 pcs	10 pcs	\$2.3076923/pcs	\$23.08

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042256



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	187703	RB23007615-3	#56 Drill Bit -Issue P/O to Altech; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	1/21/19	12 pcs	0 pcs	12 pcs	\$2.3076923/pcs	\$27.69
5	187705	RB23007615-7	#27 Drill Bit -Issue P/O to Altech; PO -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	1/21/19	10 pcs	0 pcs	10 pcs	\$2.3076923/pcs	\$23.08

Grand Total: \$120.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS



Certificat de Conformité / Certificate of Compliance

(015960-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015960 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
17-Jan-2019		Aman		042256 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB23007615-11 ✓ Rev.	RB23007615-11 ANODIZE COLOR BLACK PER IAW MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10 ✓	0	0	0
2	RB23007615-9 ✓ Rev.	RB23007615-9 ANODIZE COLOR BLACK PER IAW MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10 ✓	0	0	0
3	RB23007615-5 ✓ Rev.	RB23007615-5 ANODIZE COLOR BLACK PER IAW MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10 ✓	0	0	0
4	RB23007615-3 ✓ Rev.	RB23007615-3 ANODIZE COLOR BLACK PER IAW MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	12	12 ✓	0	0	0
5	RB23007615-7 ✓ Rev.	RB23007615-7 ANODIZE COLOR BLACK PER IAW MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10 ✓	0	0	0

DAS
38
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.